

Work Order ID 57899

April 20, 2010 7:05:29 AM



Page 1

Item ID: D412-709-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Escape Panel Modification

Start Date: 4/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/4/20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-709	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-709-011 CHG001

Disclis

For CL 10/05/17
Pho →

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

10-5-18 *(2x) SP*

120

0.00



QC4- 100% Inspect kits for completeness

Memo

0.00

QC

Quality Control

Disclis

(+2)

Dart Aerospace Ltd

W/O: 57899		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/5/18	#100	Part missing from w/o pick sheet. ADD Part to kit D3561-1 B* <u>50109</u> Qty +1 per kit - 8/10/18 x2	SL	10-5-18	2X		S 10/5/18	
		update w/o + Bom. ADD copy of new Bom for reference	AA	10.5.20			S 10/5/18	

Part No: D412-709-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D412-709-011

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Revision ID:

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Item Name: Escape Panel Modification

Start Date: 4/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/10 Req'd Qty: 2.00



Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Packaging

Packaging

0.00

Rev A

10-5-18

20

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-709-011
Location: _____

140



QC

QC21- Final Inspection - Work Order Release

0.00

10/05/19

Quality Control

Memo

0.00

mf
10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 57899

Parent Item: D412-709-011

Parent Item Name: Escape Panel Modification

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Date: 4/20/10

Required Date: 4/27/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-20A <i>ts</i>		Purchased	No			120	Each	49.0000	6.0000			
<i>6-12</i> Bolt											10-5-18 <i>SL</i>	

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST342

49

110915

49

120

Each

4,551.000

4.0000

AN960JD10L *v2*

Purchased

No



6-12 Washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST348

4551

110985

4551

120

Each

49.0000

10.0000

AN960JD616 *NAS114900663 I*

Purchased

No



Washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST347

49

113149

49

6
10-5-18 *SL*

113524 10-5-18 *SL*
24

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April 20, 2010 7:05:28 AM

Work Order ID: 57899



Parent Item: D412-709-011



Parent Item Name: Escape Panel Modification

Start Date: 4/20/10

Required Date: 4/27/10

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD616L Washer		Purchased	No			120	Each	135.0000	10.0000		10-5-10	

Warehouse
Location

Main Warehouse

ST347

111819

Loc Qty

135

135

Loc Code

120

Each

9.0000

2.0000

D3118-3

Sign Assembly

Manufactured

No

Warehouse
Location

Main Warehouse

ST037

45265

50365

Loc Qty

9

4

5

Loc Code

120

Each

4.0000

2.0000

D3136-043

Window Assembly

Manufactured

No

Warehouse
Location

Main Warehouse

ST216

56592

Loc Qty

4

4

Loc Code

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 57899

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Parent Item Name: Escape Panel Modification

Start Date: 4/20/10

Required Date: 4/27/10

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3224-1		Manufactured	No			120	Each	3.0000	2.0000			


Frame

10-5-18 S

Warehouse
Location

Main Warehouse

ST218

36312

Loc Qty

3

3

Loc Code

135.0000

16.3320

D3237-1

Manufactured

No



Seal Retainer

2

10-5-18 S

Warehouse

Location

Main Warehouse

ST414A

32825

43183

Loc Qty

135

11

124

Loc Code

2

(D3237-1-0980) cut (1) at 98.00" as per dwg ***per kit***

7 measured
8/10/05/19

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Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 20, 2010 7:05:29 AM

Work Order ID: 57899

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Parent Item Name: Escape Panel Modification

Start Date: 4/20/10

Required Date: 4/27/10

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3237-3		Manufactured	No			120	f	56.0000	16.3320			
Seal Filler												



10-5-18

Warehouse
Location

Main Warehouse

ST411

43140

Loc Qty

56

56

Loc Code

(D3237-3-0980) cut (1) at 98.00" as per dwg ***per kit***

D3239-1

Manufactured No

120

Each

19.0000

4.0000

Cover



10-5-18

Warehouse
Location

Main Warehouse

ST046

55609

Loc Qty

19

19

Loc Code

MS21042L3

Purchased

No

120

Each

1,129.000

4.0000

Nut



10-5-18

Warehouse
Location

Main Warehouse

ST300

113537

113644

Loc Qty

1129

145

984

Loc Code

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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April 20, 2010 7:05:29 AM

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Parent Item: D412-709-011



Parent Item Name: Escape Panel Modification

Start Date: 4/20/10

Required Date: 4/27/10

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6		Purchased	No			120	Each	245.0000	6.0000			



812 Nut

10-5-18

SL

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST300

245

111578

245

120

Each

28.0000

4.0000



6

10-5-18

SP20

MS35207-262

22

Purchased

No



82 Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST295

28

109840

28

4

April 20, 2010 7:05:29 AM

Shop Packet Print

Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-709

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
			X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
							D3136-043	WINDOW ASSEMBLY
			1				D3224-1	FRAME
							D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
				1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
				1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
							D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
				1		1	D3561-1	WINDOW SEAL TOOL
							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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